

Patent Abstracts of Japan

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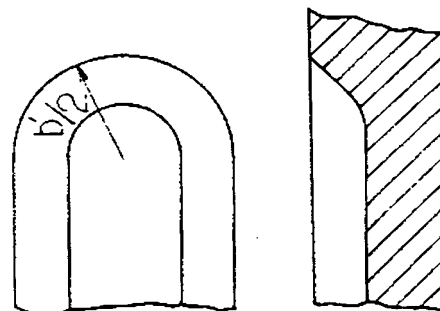
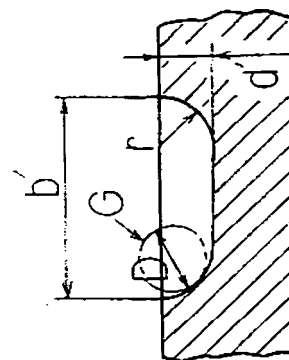
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TITLE : PRETREATMENT OF NUT BEFORE  
HOT DIP GALVANIZING



ABSTRACT : PURPOSE: To make pickling as pretreatment unnecessary and to increase an economical effect by subjecting a nut to shot blasting with shot whose diameter is a specified percentage or less of the width of a groove forming a latter, a symbol or a figure carved on the surface of the nut.

CONSTITUTION: The letter, symbol or figure such as the symbol expressing the grade of the nut prescribed by JISB1186 according to mechanical properties is carved on the surface of the nut to a width  $b'$  and a depth  $d'$ . The nut is subjected to shot blasting with shot  $G$  whose diameter  $D$  is  $\leq 60\%$  of the width  $b'$  of the resulting groove forming the symbol to increase the radius ( $r$ ) of the corners of the bottom of the groove. The nut is then hot dip galvanized without carrying out pickling.

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